

Date: Thursday, 2/7/2008 8:54:02 AM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FORWARD DOUBLER	PROTOTYPE
Job Number : 37270		
Estimate Number : 13150		
P.O. Number :	Part Number : D37021	
This Issue : 2/7/2008 S.O. No. :	Drawing Number : D3702 U/R	
Prsht Rev. : NC	Project Number : N/A	
First Issue : / / Type : R & D SM/MED FAB	Drawing Revision : U/R	
Previous Run : 37136	Material :	
Written By :	Due Date : 2/14/2008	Qty: 1 Um: Each
Checked & Approved By :		
Comment : Est Rev:A 08-01-30 new issue DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.5837 sf(s)/Unit Total : 0.5837 sf(s)

6061T6 aluminium sheet .080" thick
 (M6061T6S080)

Batch: 104921 B 8-2-7

CERTIFICATE OF CONFORMITY
 REQUIRED



2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3702

Dwg Rev: 4/R

Prog Rev: 4/R

B 8-2-7

2- Deburr if necessary

B 8-2-7



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 8-2-7

4.0	QC8	SECOND CHECK
-----	-----	--------------



ENGINEERING
 APPROVAL



Comment: SECOND CHECK

08.02.02

08/2/07

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr if necessary

Eric Charbonneau

Date: Thursday, 2/7/2008 8:54:02 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FORWARD DOUBLER

Job Number: 37270

Part Number: D37021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DOB 02-20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



**ENGINEERING
APPROVAL**

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

N/A

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

FOR ENGINEERING USE ONLY

Location: _____

DOB 02-20

10.0

QC21

FINAL INSPECTION/W/O RELEASE



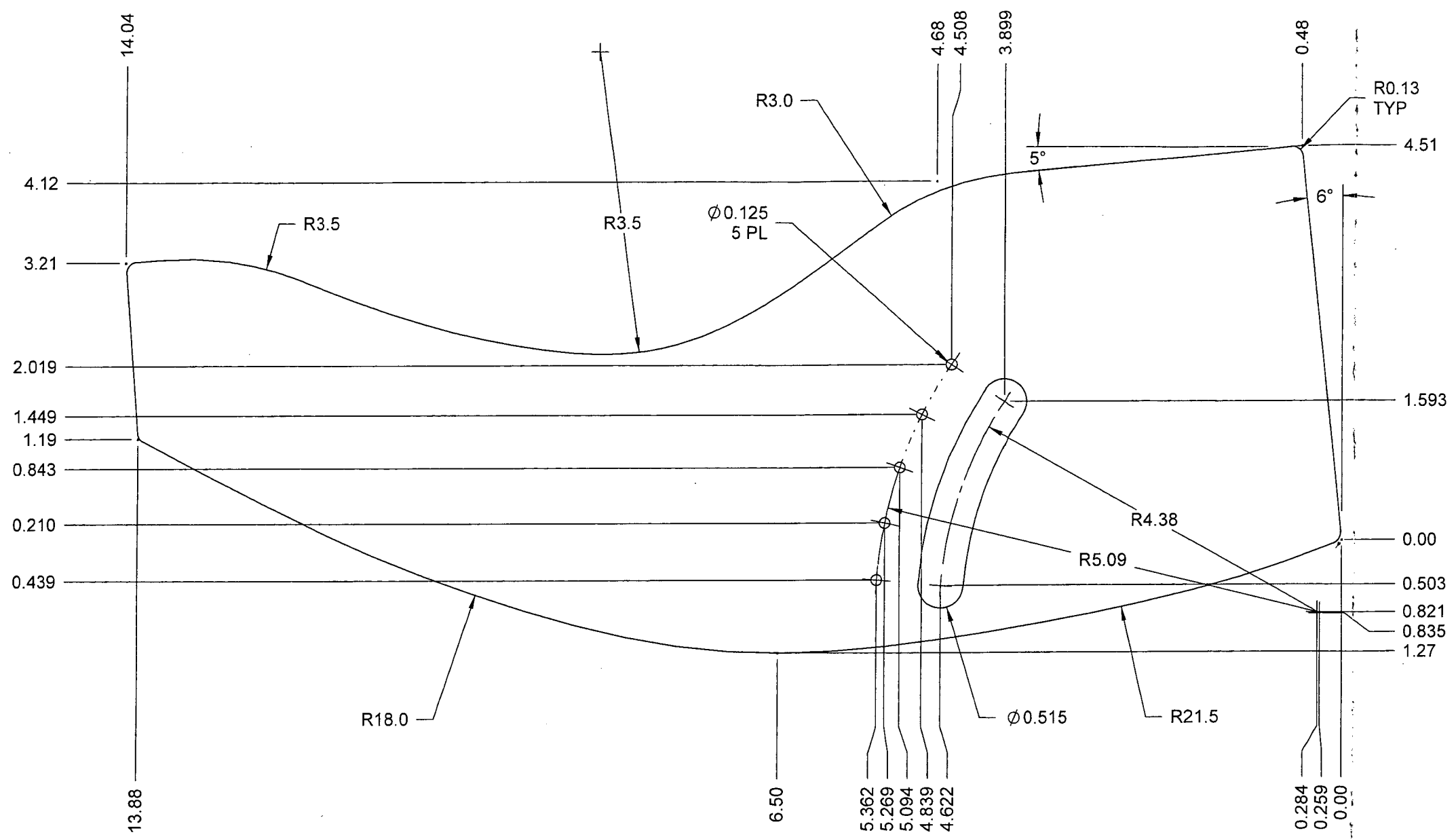
Comment: FINAL INSPECTION/W/O RELEASE

DOB 05/20

Job Completion



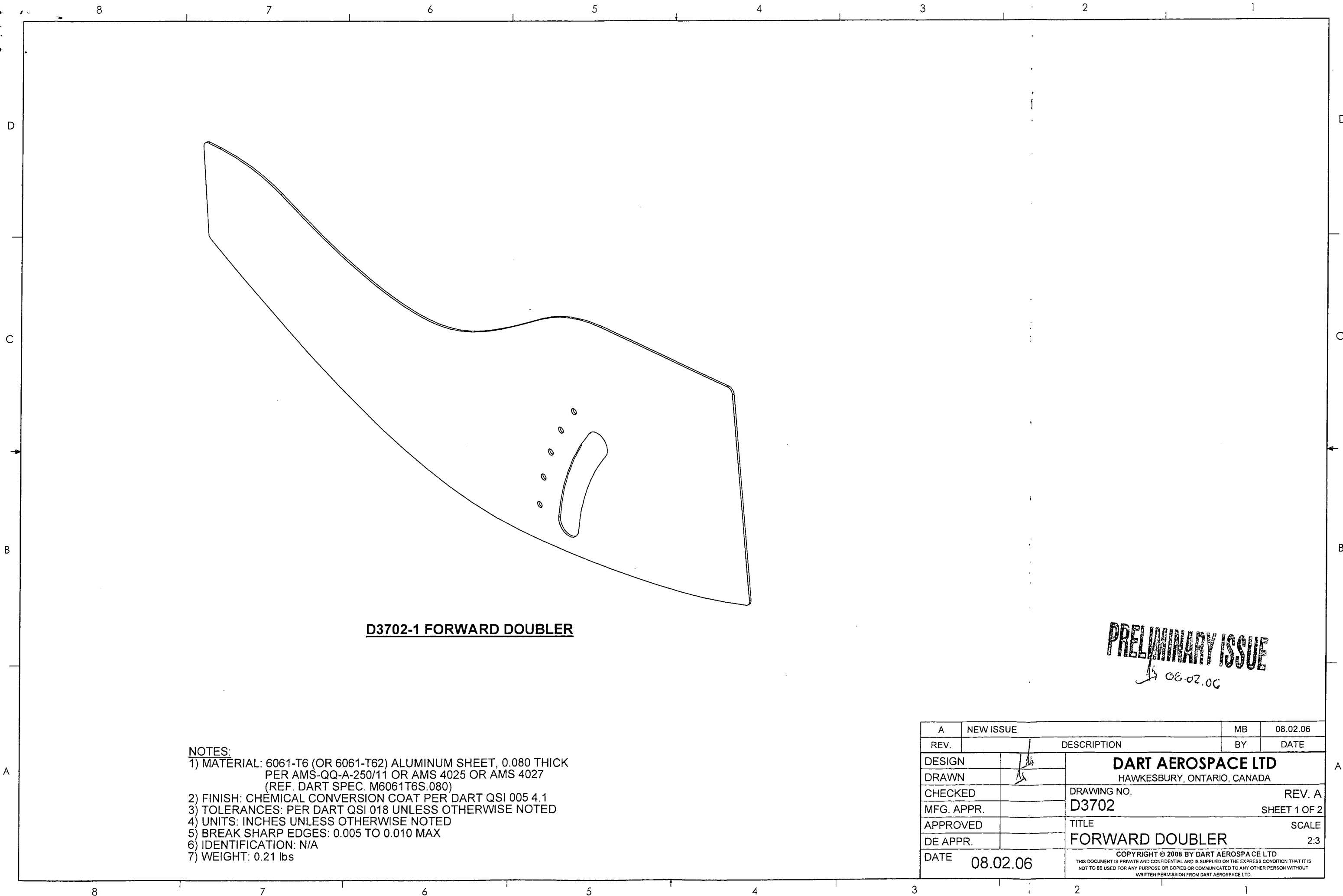
mf 08-05-16



D3702-1 FORWARD DOUBLER

PRELIMINARY ISSUE
08.02.06

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED	LE	
MFG. APPR.		
APPROVED		
DE APPR.		DRAWING NO. D3702
DATE	08.02.06	
		REV. A SHEET 2 OF 2
		TITLE FORWARD DOUBLER
		SCALE 2:3
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NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.21 lbs

PRELIMINARY ISSUE
08.02.06

A	NEW ISSUE	MB	08.02.06
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3702	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FORWARD DOUBLER	2:3
DATE	08.02.06	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Date:

07/07/04

Batch No:

1104921

Supplier:

Campi

Dart P/O:

4054

Packing Slip:

Yes ☒ No ☐

Invoice:

Yes ☒ No ☐

Receipt:

Cash ☐ Cr ☒

Release Note Attached:

Yes ☒ No ☐

Waybill Attached:

Yes ☒ No ☐

Shipment Complete:

Yes ☒ No ☐

QC6 Inspection

En attente

Work Order

Discrepancies	Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
		M304B0150x2500	12	0	0	12	
		M304S256A	32	0	0	32	
		M4130N160500K0300	40	0	0	40	

Initials of receiver (if shipment OK) Level 12

Production/Admin:

07/07/09

Date

Received/Costing

BCP 5032

Initial

CP

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

50 377-4248
50 377-5696MONTRÉAL : 514 336-4248
FAX : 514 336-4246DISTRIBUTEUR D'ACIER ET MÉTAUX SPÉCIALISÉS
STEEL AND SPECIALTY METALS DISTRIBUTORONTARIO : 1 800 667-4248
FAX : 1 866 456-4242

On a du Savoir "FER"

À / SHIP TO:

ROSPACE LTD
ERDEEN STREET
URY,FACTURE
INVOICE

N° 176759

DATE

04/07/07

BON DE LIVRAISON
PACKING SLIP

N° 123473

DATE DE LIVRAISON
DELIVERY DATE

04/07/07

TERMS / TERMS

NET 30 JOURS

TERR.

2R

REMARQUES / REMARKS

PAGE N°

001

DESCRIPTION	POIDS WEIGHT	PRIX PRICE	PAR PER *	MONTANT AMOUNT
.080 12'	192	5.700		1094.40
2 .040 8'	128	2.500		320.00
.063 12'	144	20.500		2952.00
.080 12'	144	25.650		3693.60
X 2.5	0	35.400		0.00
3/8 X .035	120	1.750		210.00
1/2 X 3	0	31.500		0.00
POIDS TOTAL TOTAL WEIGHT		728.00		

Formplus N° 8619

MATERIALS REMAIN THE PROPERTY OF "ACIER CAMPI INC." UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED. THE BUYER'S EXPENSE. • ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER TO RESPECT THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY 2% PER MONTH OR 24% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. • ANY DEFAULT IN RESPECT WITH PAYMENT BY ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE SOLD. • ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. • ANY MERCHANDISE CUT OR MODIFIED CANNOT BE RETURNED. • ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE IN CHARGE.

EN BONNE CONDITION MERCHANDISE RECEIVED IN GOOD CONDITION

A/Y M/M J/D

SOUS-TOTAL 8270.00
SUB TOTALT.P.S. 496.20
G.S.T.T.V.Q. 0.00
Q.S.T.

8766.20

CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements specified therein, including any special conditions forming a part of the description and that samples representative of the material and the sample which have been and had the mechanical properties shown on the face of this sheet.

Mark J. Webb

Mark J. Webb
Director of Non-Destructive Inspection

Kathleen P. Young

Kathleen P. Young
Quality Assurance Manager

731866

Ship Date

2007-02-19

P.O. No./Contract No.

W61242R

0

B.L. No.

2081389

Invoice No.

00000

CUSTOMER

Ship From:

Alcoa No. Item

4437904-1

W61242R

Page 1

our B 866721

Ship To:

Item Description

0.08 IN TH (+0 -.0045) X 48.8 IN W L-046875 -
046875) CAT X G0815462R03 (N/A/T 6061-T6)
COIL SHEET FOR DISTRIBUTORS TOLERANCES GUARANTEED. AMS-QQ-A-
250/11 AMS4027 REV M AMSH35.2 REV 2006 ASME-SB-
209 REV A99 ASTM209 REV 06 ((NOT
MARKED)) LIGHTLY OILED COIL SIZES: ID 20 IN
COIL WTG: MAX 6500 LB
MAX GROSS SKID WGT: 7000 LB QUAN TOL +/-10
1 CQR D138487 REV 31 CUST REQ 07-02-
17 *** N/E 07-02-24 ***

on 7/6/06

Num	Package Ticket	Lot	Weight	Quantity	UCN	PC Id/Serl
1	492928	557791	4861	1	PC	D035909
2	496818	597260	6410	1	PC	D035908
			11271	2		

Notes for CQR: D138487.31

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/11 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/11P. PROD UCT
PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/11 P ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/11.

CQR: D138487.31 - Specification Limits

Temp	Dir	UTS	TYS	ELAD
T6	Long Transv.	KSI	KSI	PCT
	Max			
	Min	42.0	35.0	10

Chemical Composition

Alloy	SI	FE	CU	MN	MO	CR	NI	TI	Other	Other
6061	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.03	0.15
Lot: 557791	Min	0.40	0.15	0.15	0.8	0.04				

Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No. Test	UTS	TYS	ELAD
T6	Long Transv.	2	KSI	KSI	PCT
			49.7	44.7	11.1

CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this inspection has been inspected visually, and that based on the visual inspection, the material meets the requirements of the specification. This report is not a statement of the quality of the material, but a statement of the results of the inspection. The inspection was performed on the material as described in the specification. The inspection was performed on the material as described in the specification. The inspection was performed on the material as described in the specification.

Inspector: *Mark J. Venable*
 Director of Manufacturing Inspection: *Mark J. Venable*

Inspector: *Mark J. Venable*
 Director of Manufacturing Inspection: *Mark J. Venable*

751066
 Ship Date: 2007-07-19
 B.L. No. 2081389
 Invoice No. 00000
 Alias No. Item 4437904-1
 Contract No. 4437904-1
 Ship From: RIVERDALE, IN.
 Page 2

SAWYER SON & CO. LP DS-37904-1

Loc: 553791 - Mechanical, Physical, Metallurgy, Quantitative Results (cont.)

49.6 44.5 11.6

Cast Number	Chemical	BT	PS	CV	HN	MS	CR	EN	TI
06706551	Actuals	0.62	0.5	0.28	0.01	0.9	0.19	0.02	0.02
Loc: 567268	- Mechanical, Physical, Metallurgy, Quantitative Results								
Temp	Dir	Test	UTS	ESL	ESL	ESL	ESL	ESL	ESL
TS	Long Transv.	2	49.8	49.8	49.8	49.8	49.8	49.8	49.8
Cast Number	Chemical	BT	PS	CV	HN	MS	CR	EN	TI
MS22023	Actuals	0.66	0.4	0.25	0.06	1.0	0.20	0.02	0.02

1035409
 1035408